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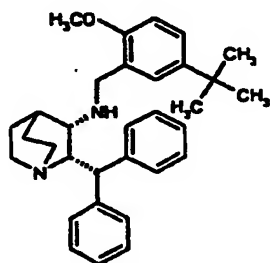
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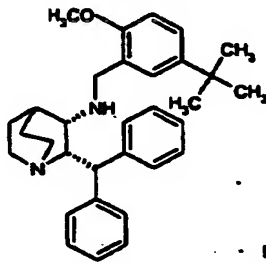
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(54) Title: PROCESS FOR PREPARATION OF 1-(2S,3S)-2-BENZHYDRYL-N-(5-TERT-BUTYL-2-METHOXYBENZYL)QUINUCLIDIN-3-AMINE



(I)



(Ia)

Ia - citrate monohydrate

(57) Abstract: This invention relates to an improved process for the preparation of (2S,3S)- 2-benzhydryl-N-(5-tert-butyl-2-methoxybenzyl)quinuclidin-3-amine, (hereinafter "compound of Formula I") and its pharmaceutically acceptable salts. In particular, the invention is directed to an improved synthesis of the monohydrate citrate salt of the compound of Formula (Ia).

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